



WILFLEX® BubbleStretch 10177BSB

DESCRIPTION

BubbleStretch Base has been specially formulated to create an opaque textured and highly stretchable ink surface.

The ink when cured provides a semi-gloss finish which is embellished with tiny pits and craters. BubbleStretch can be used with or without high density graphics.

PRINTER'S PARAMETERS

Substrates	100% cotton, blends, lycra & uncoated nylon
Bleed resistance	none
Mesh (on darks)	24-230 th/in (10-90 th/cm)
Tension (newtons) Off Contact	25-30 newtons 1/16 inch
Stencil emulsion	Direct or capillary (200-400 microns for elevated surfaces)
Squeegee type	75 durometer, 70/90/70
Squeegee blade	Sharp edge
Gel temp	220F (104C)
Cure temp	350F (177C)
Extender	none
Reducer	2% max by weight Viscosity Buster 10025VB.
Caution	Excessive modification will reduce bleed resistance and may cause problems in curing or flash curing.
Storage	65-90 F (18-32 C). Avoid direct sun. Use within one year of receipt.
Wash-up	Wilflex Screen Wash. Be sure not to scrub a HD image when cleaning.
Health & Safety data	Available upon request

FEATURES

- Textured pitted surface.
- Unique textured semi-gloss appearance.
- Embossed finished
- Super elongation
- High tensile stretch and strength
- Can be used as high density ink as well as a conventional flat print ink.
- Excellent wash properties
- For light or dark fabric grounds
- BubbleStretch Base is part of the First Base Program

SPECIAL RECOMMENDATIONS

- Add PCs, MX, or Equalizer to create custom color. Addition of pigments or finished ink to the base should not exceed 10% by weight.
- Pigment Concentrates (PCs) provide enhanced color vibrancy over a finished ink color additive.
- Single print or print/flash/print can be used to apply ink to fabric.
- Higher ink deposits will increase textured finish appearance and ink opacity.
- For one-hit opacity through coarse meshes, use a coating procedure that builds a thick, even stencil to ensure a good deposit of ink.
- Ink has special embossed characteristics when cured at 350F(177C).
- Add Natural Suede Base 10425NS- 10% by weight to reduce gloss and vibrancy of ink.
- Preprint and test all fabrics for dye migration.
- Stir plastisols prior to printing.
- Perform fusion tests before production. Failure to cure ink properly can result in poor wash fastness, inferior adhesion, unacceptable durability, and increased likelihood of dye migration. Testing procedures for plastisol fusion are outlined in the Wilflex User's Manual.
- Do not dry clean, bleach or iron the printed area.
- Any application not referenced in this product information bulletin should be pre-tested or consultation sought with PolyOne Technical Services Department prior to printing.
Email: techserviceswilflex@polyone.com

Effective 09/15/04. Wilflex products are available in every country. The information in this publication is based on information and experience believed reliable. Since many factors may affect processing for an application, processors must carry out their own tests and experiments to confirm suitability for intended use. You must make your own determination of suitability for your intended use and environmental acceptability, the safety and health of your employees, and purchasers of your product.